

Order #14269

[Dart] [lawkesbury] Job Sheet - Lajeunesse, Marie



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1270 Aberdeen St.
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Canada

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ARC

D350-591-311
Job Sheet 197606

Part No: D350-591-311

Job Qty: 10 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/11/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03. New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref CR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Large Fab - Steps - 1	10 pcs	9/2/19	9/2/19	0.00	9.91	Large Fab - 1 Large Fab - 10 Large Fab - 2 Large Fab - 3 Large Fab - 4 Large Fab - 5 Large Fab - 6 Large Fab - 7 Large Fab - 8 Large Fab - 9 Large Fab - 11 (Various)		SLU
120	QC 9	10 pcs	9/2/19	9/2/19	0.00	0.00	QC 9 - 10 QC 9 - 18 QC 9 - 24 QC 9 - 43 QC 9 - 50 QC 9 - 9		AUG 21 2019
130	QC 5	10 pcs	9/2/19	9/2/19	0.00	0.00	QC 5 - 10 QC 5 - 12 QC 5 - 17 QC 5 - 18 QC 5 - 19 QC 5 - 22 QC 5 - 24 QC 5 - 3 QC 5 - 43 QC 5 - 49 QC 5 - 51 QC 5 - 58 QC 5 - 68		AUG 21 2019

PRIORITY

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				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
140	Handfinish - 1-1 Chemical-B4B	10 pcs	9/2/19	0.00 1.84	Handfinish - 1 - 1 - B4B	BEB19-08-22
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	QC 7	10 pcs	9/2/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	BAS
					QC 7 - 48	43
					QC 7 - 51	9-89
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
180	Large Fab - Steps - 2 - B4B	10	9/2/19	0.00 9.91	Large Fab - 1 - B4B	

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	pcs				Large Fab - 10 - B4B	SLA
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
190 QC 10	10 pcs	9/2/19	0.00 0.00		QC 10 - 10	DAS AUG 27 2019 50 9-89
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
200 QC 5	10 pcs	9/2/19	0.00 0.00		QC 5 - 10	DAS AUG 27 2019 68 9-89
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
210 Handfinish - 1-2- Chemical- B4B	10 pcs	9/2/19	0.00 1.84		Handfinish - 1 - 1 - B4B	★ AUG 27 2019
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	

7/11/2019 •

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220 Powdercoat - 1 White Gl(A)- B4B	10 pcs	9/2/19	0.00 2.90	Powdercoat - 1 - B4B	
<i>11/193459.</i> <i>START: 11:40 OUT: 1:30 FINISH: 12:10</i>				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				Handfinish - 3 - 1 - B4B	
230 Handfinish - 3-1- WingWalk- B4B	10 pcs	9/2/19	0.00 1.84	Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
240 QC 3	10 pcs	9/2/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
250 Packaging 1-1 - Pick Kit - B4B	10 pcs	9/2/19	0.00 0.00		

DAS
81
9-89

AUG 29 2019

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260	QC 4	10 pcs	9/2/19	0.00 0.00	Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
					QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
270	Packaging 3-1 - Stock - B4B	10 pcs	9/2/19	0.00 0.00	Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					DC - 1 - B4B	
					DC - 2 - B4B	
					QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	
275	DC - 1 - B4B	10 pcs	9/2/19	0.00 0.00	DC - 1 - B4B	
280	QC 21 - FG	10 pcs	9/2/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

Map B

(QC 69)
9/3/2019
MD

NL 3/27/19 MB

DAS
21

SEP 03 2019

DAS
21
9-29

SEP 01 2019

Part Op 110 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig
 Descriptions: DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush
 120 - (QC9- Inspect visual per QSI004- Fusion Welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 180 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.
 190 - (QC10- Inspect visual per QSI004- ground welds)
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (Chemical Conversion Coat per QSI005 4.1)
 220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 230 - (Wing Walk as per dwg QSI005 4.4 Batch 5182142)
 240 - (QC3- Inspect Part Finish)
 250 - (Pick Kit)
 260 - (QC4- 100% Inspect kits for completeness)
 270 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPPD350-591-311 Location : FG109
 275 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-311 CHG001
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5198236
D3219-1	Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5199742
D3272-1	Step	10 pcs (1 ea)	110-Large Fab - Steps - 1	5200827
D3065-041	Step Leg Assembly	10 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	5208226
D3066-1	Spacer	20 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	5198132
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	5141237-4
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5159552
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5107282
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5303531
D2230-3	Mounting Lug	40 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5194058
D2618	Bushing	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5172342
D2856-400-720	Abrasion Strip 4" X 7.20"	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5208212
D2230-3	Mounting Lug	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5194058
D3278-041	Support Assembly	10 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5153054
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5204283
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5192444
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5160202
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5301031
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	520505196
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5103640

011710

5145362
X04

5208685 (X10LH1)

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	20	39	0
	D3219-1	20	9	0
	D3272-1	10	10	0
180-Large Fab - Steps - 2 - B4B	D3065-041	10	2	0
	D3066-1	20	43	0
	MS20600-AD4W4	160	2,096	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	20	366	0
	AN4-13A	80	1,446	0
	AN5-36A	20	212	0
	D2230-3	40	775	0
	D2618	20	218	0
	D2856-400-720	20	28	0
	D3235-1	20	329	0
	D3278-041	10	3	0
	MS21042L3	20	1,099	0
	MS21042L4	80	2,008	0
	MS21042L5	20	401	0
	NAS1149D0363J	40	1,480	0
	NAS1149D0463J	160	3,292	0
	NAS1149D0563J	40	2,178	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____		DISPOSITION		DEPARTMENT/PROCESS					
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QS042)					
Description Work Order Deviation		Disposition							
		Completed By							
		Lead hand / Supervisor							
		QC / QA Coordinator							
Root Cause		FAULT CATEGORY							
Operator ☐		Pressure/Forced ☐		Contamination ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Folio/Program ☐		Outside Tolerance ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Grain Direction ☐		Drawing ☐	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Finish ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Out of Sequence ☐		Misread ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐		Off-set/Set-up ☐			
Human Factors ☐		Other/Details:							

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Accept-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Accept-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Accept-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Accept-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Accept-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Accept-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]